

Work Order ID 84369-2

May-10-12 2:34:59 PM

Sp/7

84369

Page 1

Item ID: D4062-1

Accept

Revision ID:

Item Name: Upper Tank Support

Start Date: 10/05/2012 Start Qty: 4.00

4

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/10 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D4062 | C | | | | | | | | |

100

100

Waterjet

FLOW CNC Waterjet

OHmw 1" Blk

102

102

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

12-6-7

4

0

JM

12-6-6

105

105

HAAS I

HAAS CNC vertical machine #1

Memo

0.00

MILL AS PER DWG AND FOLIO FA949

DWG REV: C

FOLIO REV: ATT

12-6-7

1

4

12-6-7



Work Order ID 84369

May-10-12 2:34:59 PM

84369

Page 2

Item ID: D4062-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Upper Tank Support

Stop

NS2

Start Date: 10/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

106

QC2- Inspect parts off machine FAI/FAIB

0.00

106

QC

Quality Control

29 12-C-7

1d

A 12-6-7

130

QC8- Inspect parts - second check

0.00

130

QC

Quality Control

B a 12/06/07

1 d

140

Identify as per dwg & Stock Location: W117

0.00

140

Packaging

Packaging

Memo

0.00

1 d 12/06/07



Work Order ID 84369

May-10-12 2:34:59 PM

84369

Page 3

Item ID: D4062-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Upper Tank Support

Stop

NS2

Start Date: 10/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 24/05/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

12/6/11 JH

150

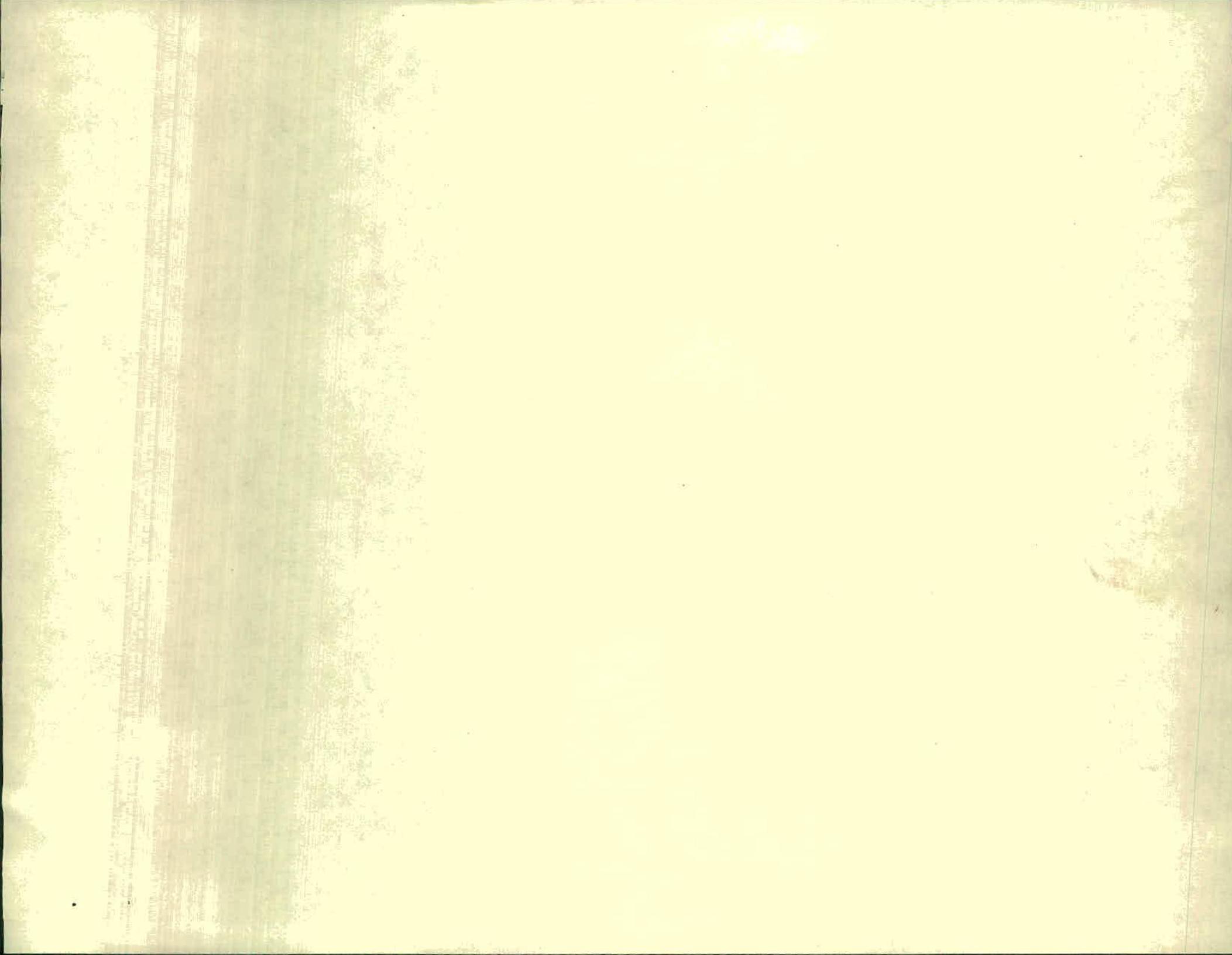
QC

Quality Control

Memo

0.00

MF
12-04-08



Picklist Print

May-10-12 2:35:02 PM

Page 1

Work Order ID: 84369

84369
D4062-1

Parent Item: D4062-1

Parent Item Name: Upper Tank Support

Start Date: 10/05/2012

Required Date: 24/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-06-22 JLM VERIFIED BY:DD
REV:B AS PER REV B 11-11-23 JLM VERIFIED BY:DD
AS PER REV C 12-03-08 JLM VERIFIED BY:DD

IPP
IPP REV:C

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10 | | Purchased | | No | | | sf | 53.2100 | | 14.4 | | | |

MUHMWR10

UHMW 1" Black

**

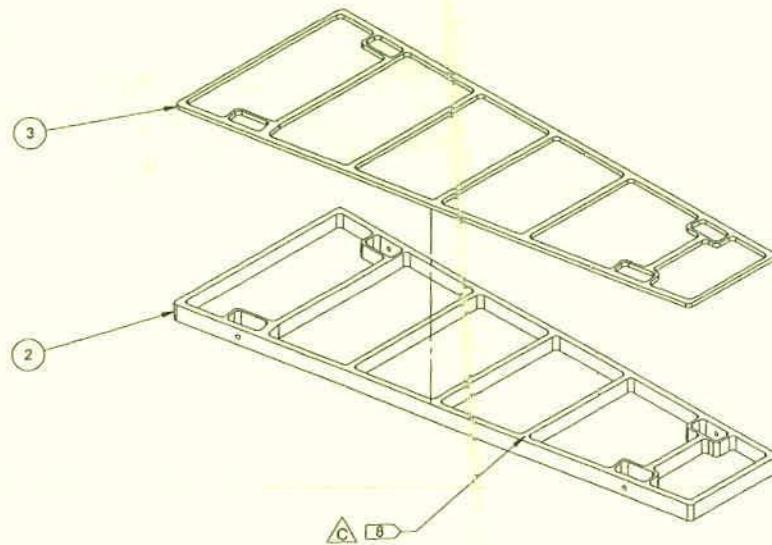
B12-6-5

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT018 | 30.1 | |
| 120972 | 3 | |
| 121346 | 27.1 | |
| MAT019 | 1.5 | |
| 118814 | 1.5 | |
| ST052 | 21.60999474 | |
| 121277 | 12.8 | |
| 121278 | 8.80999474 | |
| | 121954 | |
| | 121954 | |

JM
12-6-6



| ITEM NO. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|--------------|-------------|-----------------------|
| 1 | X | D4062-041 | TANK SUPPORT ASSEMBLY |
| 2 | 1 | D4062-1 | LOWER TANK SUPPORT |
| 3 | 1 | D4062-3 | UPPER TANK SUPPORT |



D4062-041 TANK SUPPORT ASSEMBLY

NOTES:

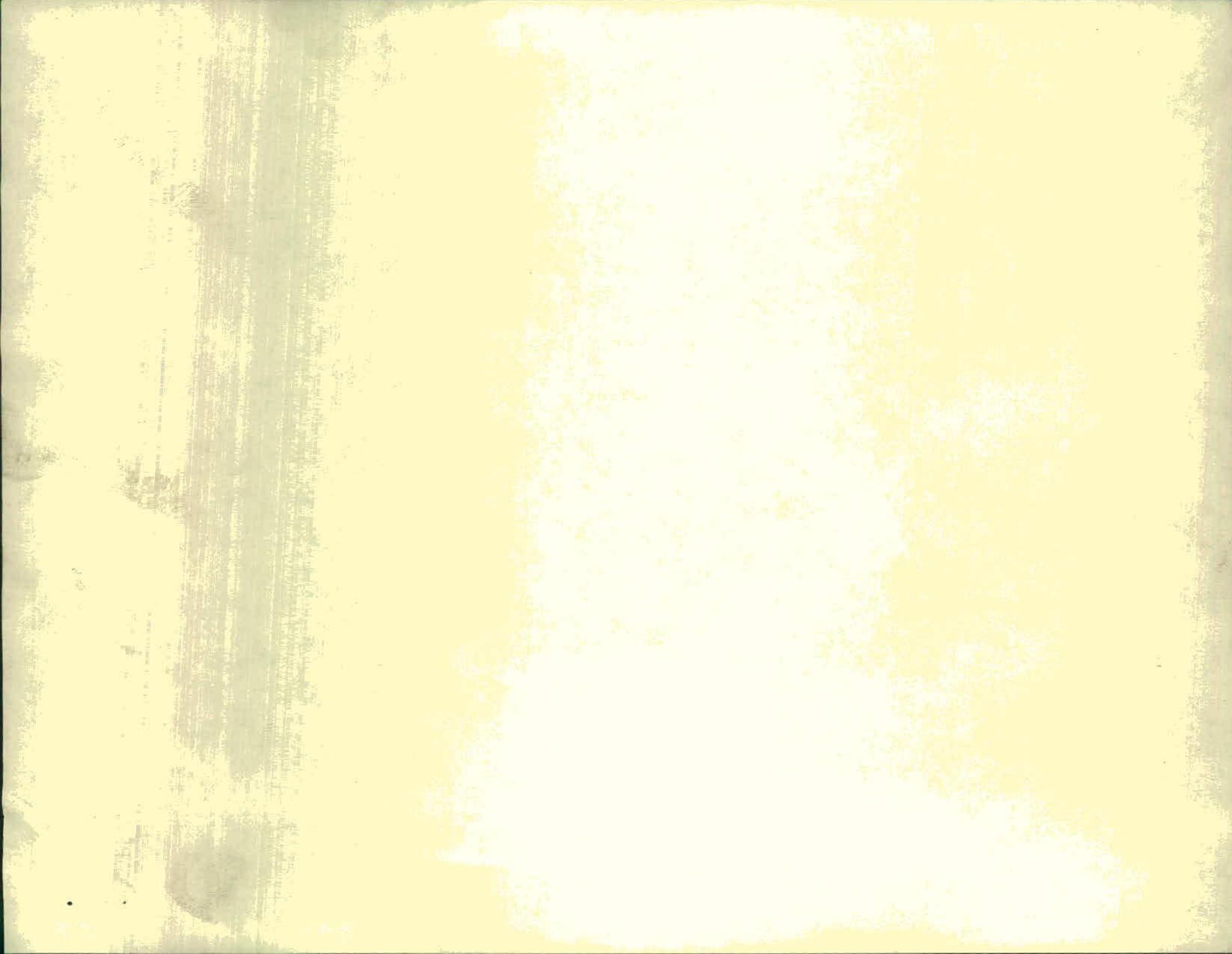
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.91 lbs
- 8) BOND ITEMS 2 & 3 TOGETHER USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

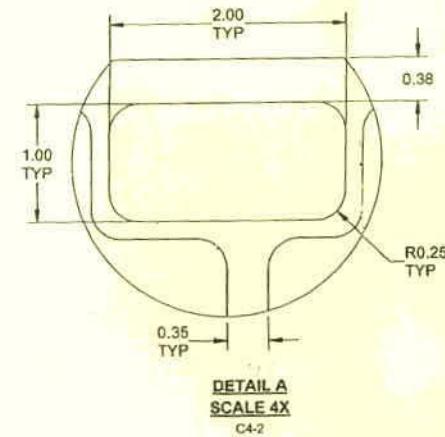
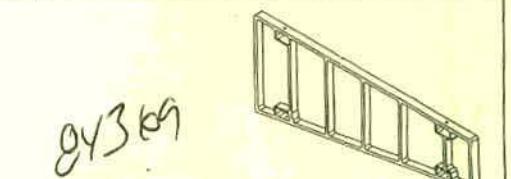
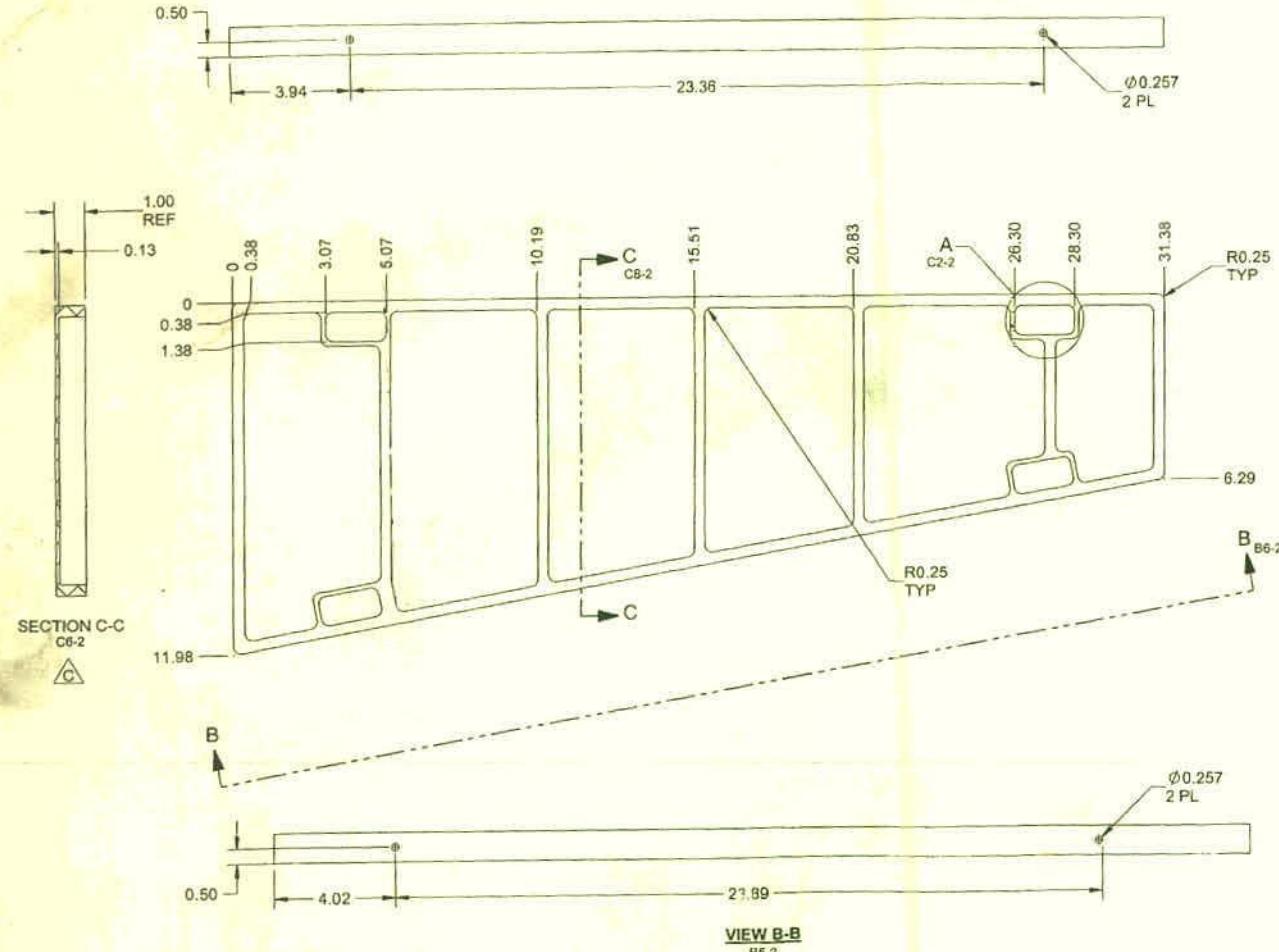
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. EY367 MLJ
12/05/10

2012-03-02 b
JW

| | | | |
|------------|---|-----------------------------|----------|
| C | REMOVE HARDWARE TO ATTACH ITEMS 2 & 3. REMOVE CBORE | DC | 11.12.14 |
| B | MODIFIED DIMS & DESIGN OF -1, ADDED -3/041 | DC | 11.09.29 |
| A | NEW ISSUE | HS | 10.07.26 |
| REV. | DESCRIPTION | | |
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D4062 | |
| MFG. APPR. | | REV. C | |
| APPROVED | | SHEET 1 OF 3 | |
| DE APPR. | | TITLE TANK SUPPORT | |
| DATE | 11.12.14 | SCALE NTS | |

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DETAIL A
SCALE 4X
C4-2

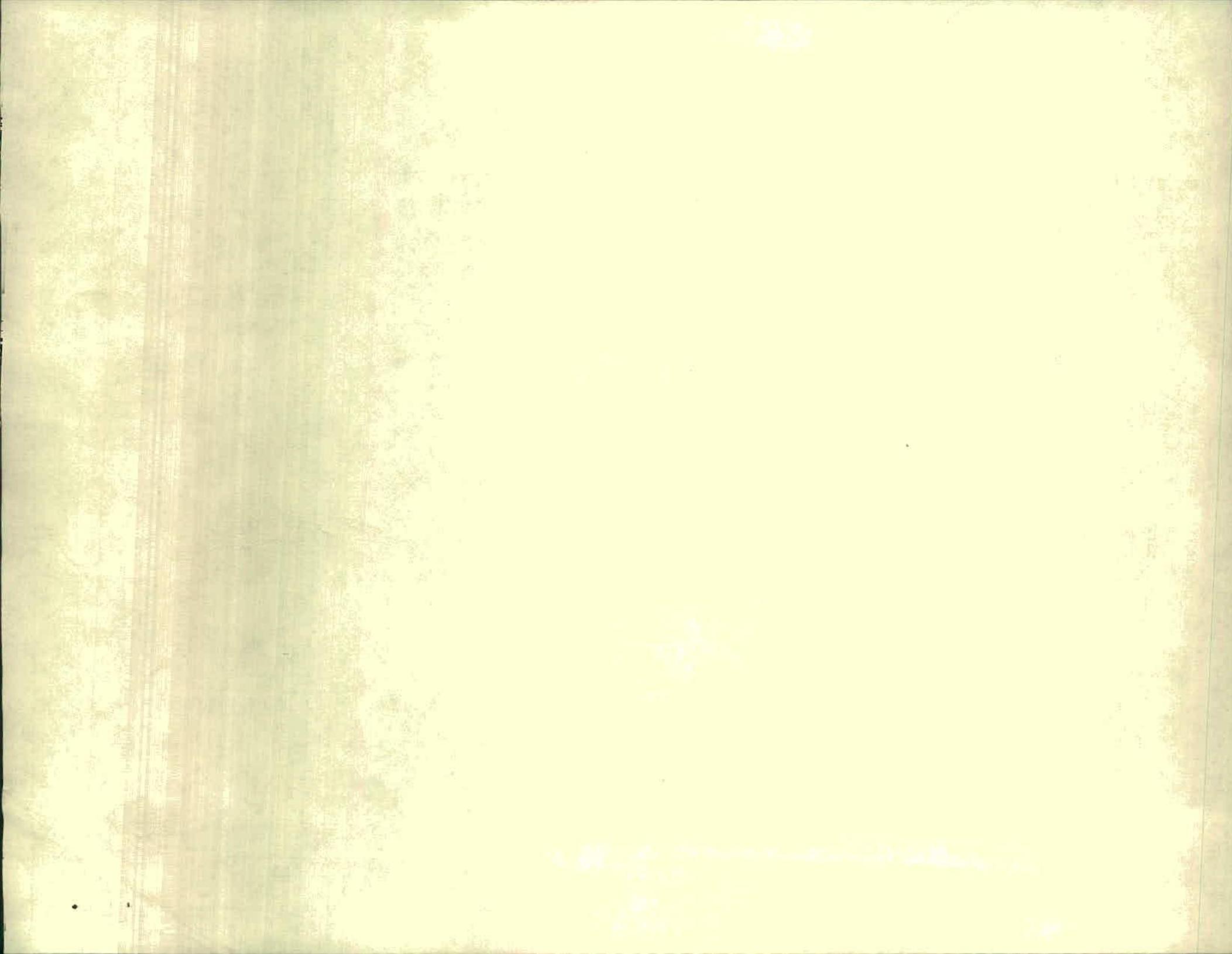
RELEASE
2012-03-02
JN

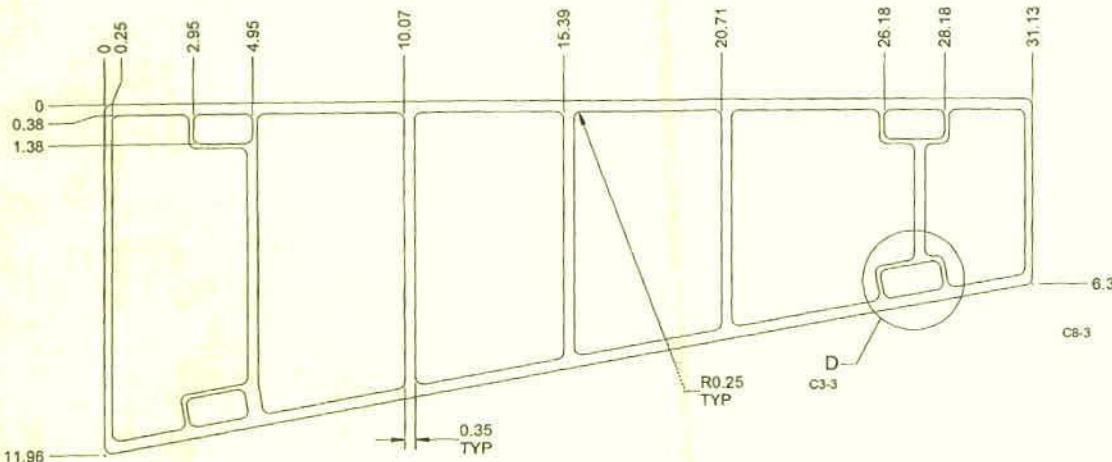
- NOTES:**
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMB10
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.53 lbs
 - 8) CUT PER D4062-1.DXF
 - 9) MAXIMUM INSIDE RADIUS = 0.250

D4062-1 LOWER TANK SUPPORT

| | | |
|------------|-----------|------------------------------|
| DESIGN | <i>BC</i> | DART AEROSPACE LTD |
| DRAWN | <i>BC</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>BC</i> | DRAWING NO. D4062 REV. C |
| MFG. APPR. | <i>BC</i> | SHEET 2 OF 3 |
| APPROVED | <i>BC</i> | TITLE TANK SUPPORT SCALE NTS |
| DE APPR. | <i>BC</i> | DATE 11.12.14 |

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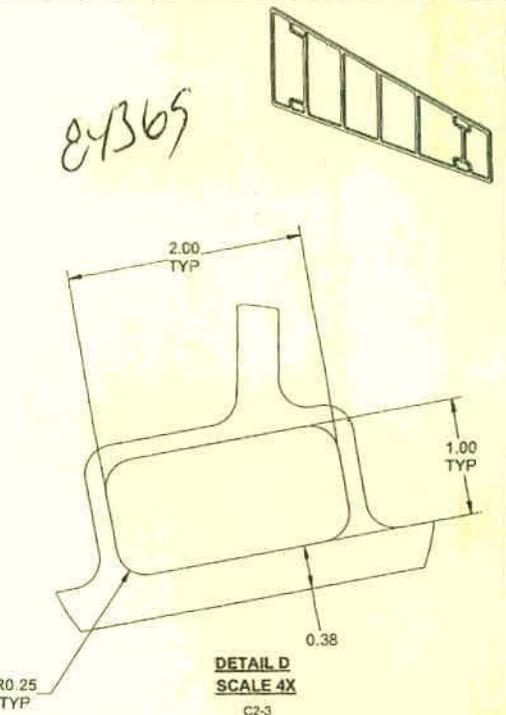




D4062-3 UPPER TANK SUPPORT

NOTES:

- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 0.25 THICK
REF DART SPEC MUHMB025
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.37 lbs
- 8) CUT PER D4062-3.DXF

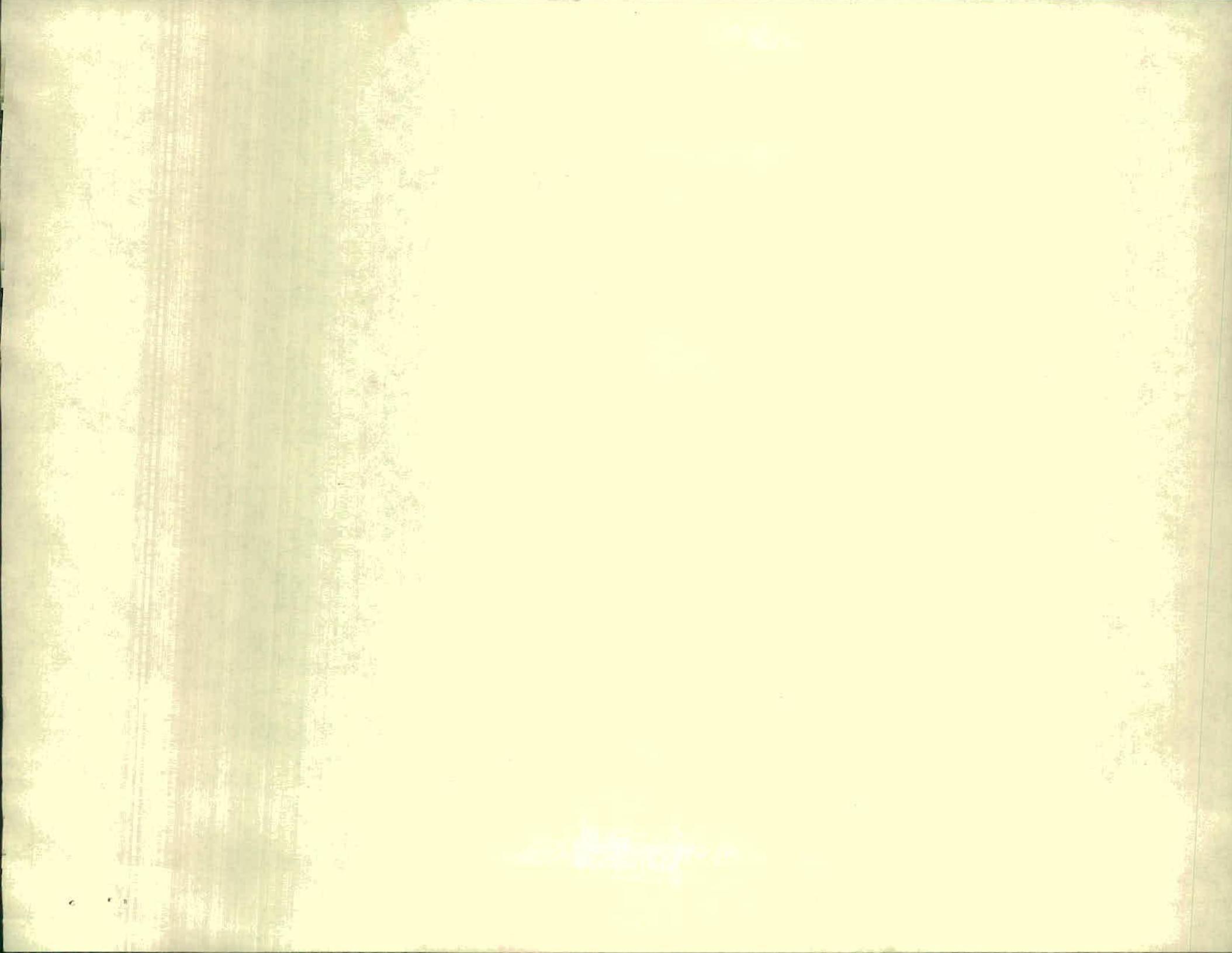


DETAIL D
SCALE 4X

2012-03-02
A

| | | |
|------------|-----------|-----------------------------|
| DESIGN | <i>SC</i> | DART AEROSPACE LTD |
| DRAWN | <i>SC</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>SC</i> | REV. C |
| MFG. APPR. | <i>SC</i> | SHEET 3 OF 3 |
| APPROVED | <i>SC</i> | TITLE |
| DE APPR. | <i>SC</i> | SCALE |
| DATE | 11.12.14 | NTS |

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| | | |
|---------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 84/369 |
| Description: LOWER TANK SUPPORT | Part Number: | D4062-1 |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | | | | | |
|--------------|-----------|-------------|----------|-----------------------|--|
| Measured by: | RG / J.D. | Audited by: | B.A. | Preliminary Approval: | |
| Date: | 12-6-7 | Date: | 12/08/07 | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |

H:\FORMS\Quality Assurance\approved QA\FAI revE

10.04.15

